

Date: Saturday, 14/03/2009 11:10:41 AM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STUD
Job Number	: 46491		
Estimate Number	: 11120		
P.O. Number	:	Part Number	: D30591
This Issue	: 14/03/2009 S.O. No. :	Drawing Number	: D3059 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: A1
Previous Run	:	Material	:
Written By	: <u>J.L. 04.03.14</u>	Due Date	: 21/03/2009
Checked & Approved By	:	Qty:	<u>20</u> Um: Each
Comment	: Est. A 04.03.25 New issue KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4130N-R0.750	4130 steel RD bar .750"
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Comment: Qty.: 0.1749 f(s)/Unit Total: 1.7493 f(s)
4130 steel rod .750"

Material: AISI 4130N Bar per MIL-S-6758 or AMS 6348/ 6370/ 6528 Ø0.750"(M4130N-R0.750)

Batch: M109135

Threads per MIL-S-7742

Identify for D3059-1

SA 09/03/16

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
Turn blank as per Folio FA400 and Dwg D3059

SA 09/03/16

(20)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 09/03/16

(20)

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

J.F. 09/03/23

(20)

Cut groove as per Folio FA400 and Dwg D3059 Identify as D3059-1

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 09/03/23

(20)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STUD

Job Number: 46491

Part Number: D30591

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

86 09/03/23

7.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: ~~8540~~

Finish: Cadmium plate per QQ-P-416F Class 1, Type II

Material release note is required.

C209/04/23

16/05/19 (20)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

Identify and Stock

Location: 5762

16/05/19 (20)

09/05/19 (20)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/19

Job Completion



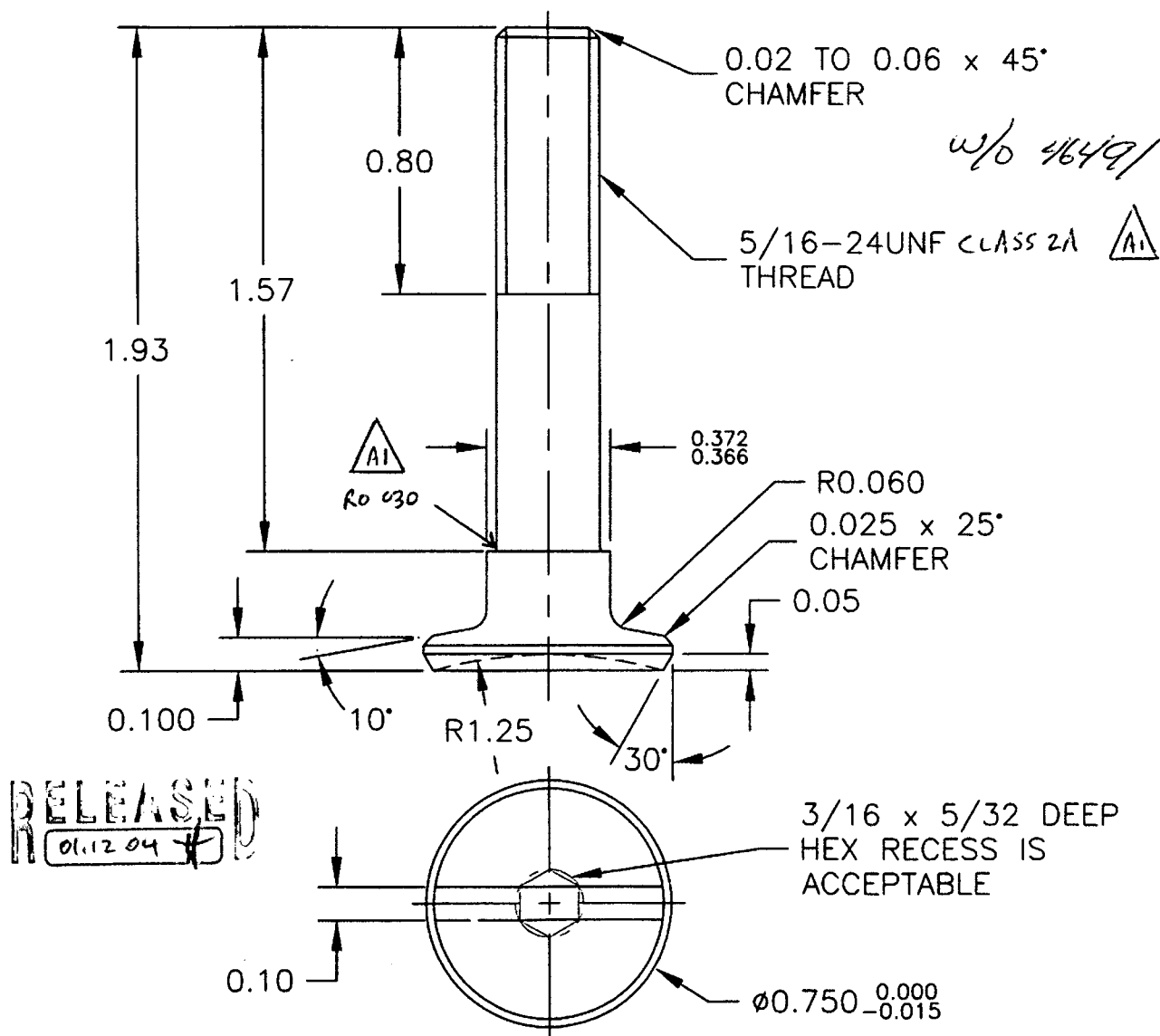
MF 09-05-19

8.1 inspect work to inspect
808/05/19 (x20)



DESIGN #	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3059	REV. A SHEET 1 OF 1
DATE 01.11.27		TITLE STUD	SCALE 2:1
A	01.11.27	NEW ISSUE	
AI	#117 040401	ADP 20030 + CLASS 2A	

SPECIFICATION CONTROL DRAWING



D3059-1:

- 1) POSSIBLE SUPPLIER: ANCRA INTERNATIONAL P/N 40110-10
- 2) MATERIAL: AISI 4130N BAR PER MIL-S-6758 OR AMS 6348/6370/6528
MIN TENSILE STRENGTH 180 KSI
- 3) THREADS PER MIL-S-7742
- 4) FINISH: CADMIUM PLATE PER QQ-P-416F CLASS 1, TYPE II
- 5) ALL DIMENSIONS ARE IN INCHES.
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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**CERTIFICATE OF
CONFORMANCE**

**CADORATH PLATING CO. LTD.
2150 LOGAN AVENUE
WINNIPEG, MANITOBA R2J-0J1**

DATE: May-14-2009

CONSIGNEE TO: Dart Aerospace Ltd.
1270 Aberdeen St.
Hawksbury, ON K6A 1K7

W/O #: 85992
INVOICE #: 44366

**CONTRACT OR
PURCHASE ORDER #** PO00008621

DESCRIPTION: TEE SCREW

QTY 20

P/N # d3059-1

S/N # B46491

**CADMIUM PLATED IAW AMS-QQ-P-416B, TYPE 2 YELLOW, CLASS
1. BAKE HEAT CHART #10441 & #10448.**

S 02/05/19

**CERTIFICATE: I certify that the items indicated here on have
been inspected and tested and conform to all specifications
and requirements detailed on the contract or purchase order.**

Approved Inspector:



A large, stylized handwritten signature in black ink.